DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023578
Date Inspected: 05-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☐ Yes ☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☐ Yes ☑ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 11
This QA Inspector observed the following work in progress for Bay 11.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Wang Chuany Xin, CWI Shi Yen.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; Bike Path (see photo)
PCMK: BK012A1-001
Weld No: 043
Welder: 046704
WPS-B-P-2212-TC-U4b

Components; Tower (see photo)
PCMK: WSD1-TBSA7-4AB
Weld No: All
Welder: 041271
WPS-B-P-2214-TC-U5b

Components; Tower
PCMK: ESD1-TBSA7-4AB
Weld No: All
Welder: 202354
WPS-B-P-2214-TC-U5b

Trial Assembly
This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CE
PCMK: VP3007-001
Weld No: 043,044,057,070
Welder: 058102
Weld Repair No. B-WR20767
WPS-345-SMAW-1G(1F)-FCM-Repair-1

Components; OBG 13 E
PCMK: SEG3019B
Weld No: 029,039,040
Welder: 215553
Weld Repair No. B-WR20830
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 13 E
PCMK: SEG3019C
Weld No: 039,041,042,044
Welder: 215553
Weld Repair No. B-WR20830
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E
PCMK: SEG3019L
Weld No: 015,018,021
Welder: 044779
WPS-B-P-2112-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS). Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE to 13CE
PCMK: OBE13
Weld No: 002,003
Welder: 050242, 044772, 052696
WPS-B-T-2231T-ESAB-1

Components; OBG 13BE to 13CE
PCMK: SA3030-005
Weld No: 001,003,005,007
Welder: 050977
WPS-B-T-2231-ESAB

Components; OBG 13BE to 13CE
PCMK: SA3030-006
Weld No: 001,003,005,007
Welder: 050977
WPS-B-T-2231-ESAB

Components; OBG 14E
PCMK: SEG3007AE
Weld No: 093,095
Welder: 055564
WPS-B-T-2231-ESAB

Heat straightening of PCMK: LD3041A under approved Heat Straightening procedure, HSR1 (B)-10321. The in process temperature was observed as 420°C. The ZPMC QC was identified as Shen Jian Bo. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 30mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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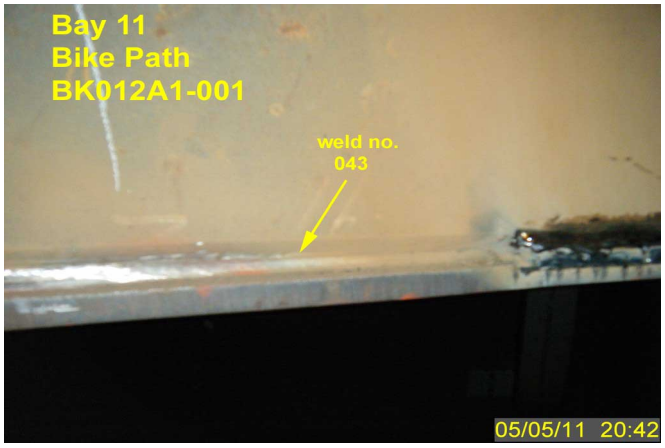

Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer